

Work Order ID 51288

August 14, 2009 7:48:02 AM



Page 1

Item ID: D2282-041

Accept



Setup Start



Revision ID: E

Stop



Item Name: T Assembly

Start Date: 08/14/2009 Start Qty: 29.00



Cust Item ID:

Required Date: 08/19/2009 Req'd Qty: 29.00



Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: *09-08-14*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2282

Rev E

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per D2282-041 'T' Handle Assembly ☐ Grind chamfers and ensure full penetration.as per dwg D2282 ☐ *****brush weld right after welding, to take color off *****☐ A/RER316L SS Filling Rod *H102421.*

SP 09.08.17.

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 09-08-19

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Tumble

EB 9-8-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

=> S 08/08/25

count
(29)

/

140



Packaging

Packaging

Identify as per dwg & Stock Location: 261

0.00

Memo

0.00

P 08/26 (29)

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/08/26 HJ

BL 09-8-24

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 51288



Parent Item: D2282-041RevE



Parent Item Name: T Assembly



Start Date: 08/14/2009

Required Date: 08/19/2009

Comments:

Start Qty: 29.00

Required Qty: 29.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2282-3RevE  Tube		Manufactured	No			100	Each	29.0000	29.0000 			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

48279

29

29 2009.08.14

D2282-5RevE



Manufactured No

100

Each

63.0000

29.0000


Tube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

63

46429

18

48281

45

18.
11 2009.08.14

W/O:		WORK ORDER CHANGES					
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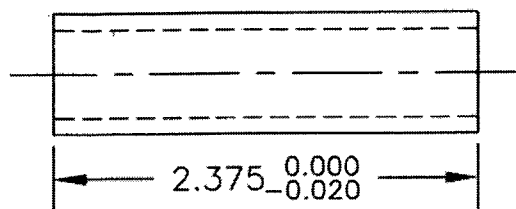
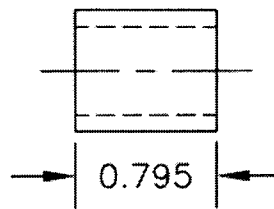
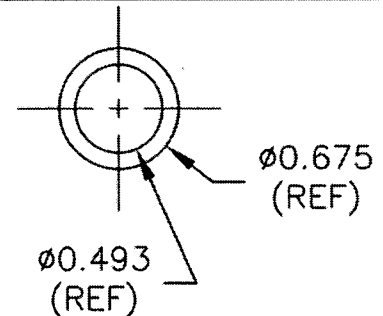
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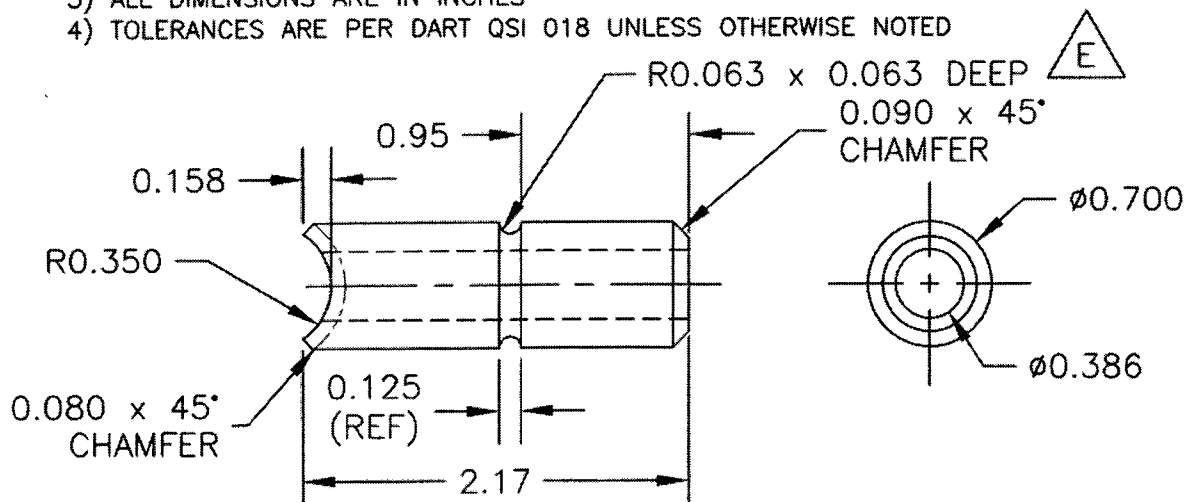
NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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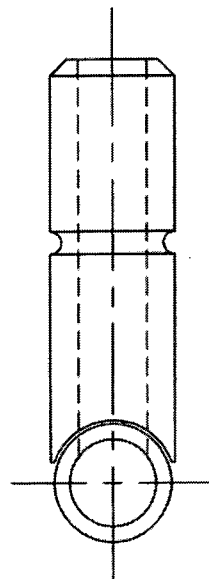
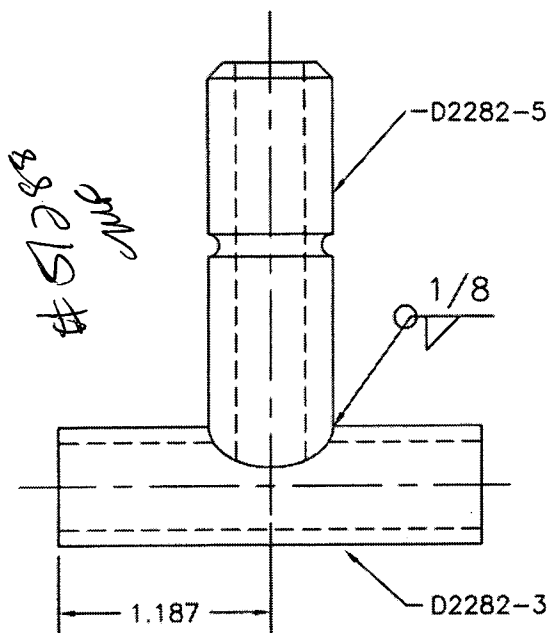
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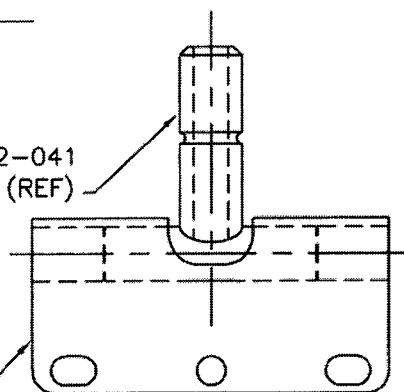


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



RELEASED
[Signature]
05/09/16

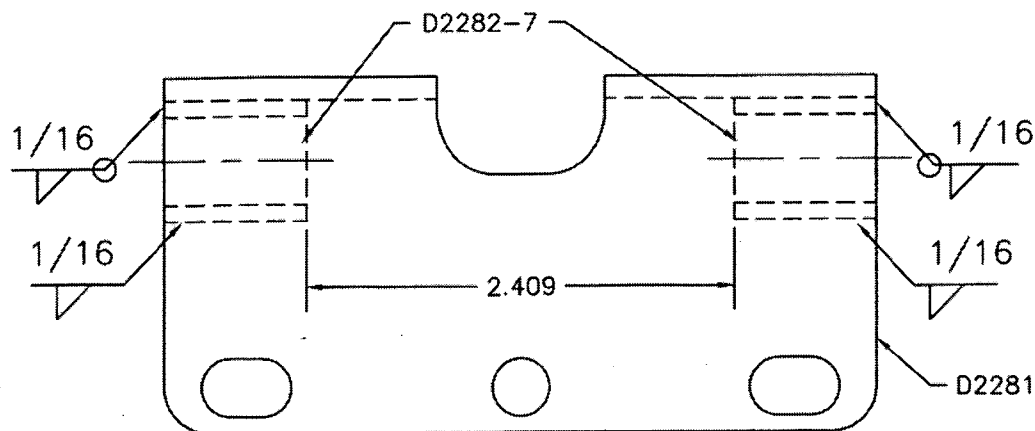
D2282-041
(REF)



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

D2282-043
(REF)

GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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